



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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D3622-1**Job Sheet 212794**

Part No: D3622-1

Job Qty: ~~20~~ ^{30 pcs} pcsDAS
21
9-89

Part Name: Ball Stud



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/4/20

Job Tracking No:

Due Date: 10/5/20

Created By: Dana Andrews

Type: Stock

Description:

Note: DWG REV D IPP Rev:A New Issue 07-04-24 JLM

Ship Via:

Bill of Materials**Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	20 pcs	10/5/20	10/5/20	0.50	2.60	Hardinge - 1		
110	QC 2	20 pcs	10/5/20	10/5/20	0.00	0.00	QC 2 - 1		20-09-13
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		



Container No: S299924



Part: D3622-1

Job No: 212794

Serial No/Batch: S299924

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Email: sales@dartaero.com
www.dartaerospace.com

Date: 09/13/20

					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 2 - 76	
					QC 2 - 86	
					QC 2 - 83	
120	QC 8	20 pcs	10/5/20	0.00 0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					QC 8 - 66	
					QC 8 - 73	
					QC 8 - 82	
130	Packaging 3-1 - Stock - B4B	20 pcs	10/5/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	

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					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
140 QC 21 - SA	20 pcs	10/5/20	0.00 0.00		QC 21 - SA - 21	DAS 21
					QC 21 - SA - 70	SEP 16 2020
					QC 21 - SA - 9	
					QC 21 - SA - 77	
					QC 21 - SA - 28	

Part Op 100 - (Hardinge) 1-TURN AS PER FOLIO FA686 & DWG D3622 ,
 Descriptions: 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M303H0.500	303 Hex Bar .500	2.1600 ft (.108 ea)	100-Hardinge - 1	S232/53 443/9

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Hardinge - 1	M303H0.500	2	17	0

Part Specifications
Specifications could not be found.

Plex 9/4/20 8:38 AM Dart.Andrews.Dana

DART AEROSPACE LTD		Work Order:	
Description: Ball Stud		Part Number:	D3622-1
Inspection Dwg: D3622	Rev: D	Page 1 of 1	

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.58	+/-0.030	.57	/		caliper	DCH-05
0.50	+/-0.030	.498			"	"
Ø0.394	+/-0.010	.3935			"	"
Ø0.310	+/-0.010	.309			"	"
Ø0.215	+/-0.010	.22			"	"
0.155	+/-0.010	.15			"	"
0.313	+/-0.010	.31				optical comparator
0.478	+/-0.010	.479				"
0.630	+/-0.010	.629				"
0.125	+/-0.010	.12				caliper DCH-05
0.563	+/-0.010	.563			caliper	"
1.19	+/-0.030	1.19			caliper	"
0.3125-24	Min = 0.3053	.3125-24			Net	Ref
UNF-3A	Max = 0.3125	.309			micrometer	DCH-01
M.O.W.	Min = 0.3336 Max = 0.3363					
M.O.W.	.3213 to .3186	.319	✓		wire .024	micrometer DCH-01

DAS

Measured by: <i>De</i>	Checked by: <i>20</i> <i>9-89</i>	QC Inspector:
Date: <i>20/09/13</i>	Date: <i>20-09-16</i>	Date:

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD	
B	10.02.02	Dwg Rev updated	KJ	
C	11.02.18	Dimensions updated per Dwg Rev C	KJ	
D	16.06.24	Dwg Rev updated	KJ	
E	16.10.13	Dimensions updated	KJ	<i>[Signature]</i>